

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009225**Date Inspected:** 25-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet (QA inspector) was present during the times noted above for observations relative to the work being performed.

Bay 8

This QA Inspector, George Goulet, proceeded to the Bay 8 in response to a ZPMC notification of witness inspection #4288 for magnetic particle (MT) inspection of the following:

This QA Inspector, George Goulet, performed random visual inspection (VT) of the area previously tested and accepted by ZPMC Quality Control CWI Sun Bo (QC1). The members were identified as OBG floor beams FB204-037, FB204-038, FB204-039, FB204-040, FB205-037, FB205-038, FB205-039, FB205-040. This QA inspector began reviewing welds on one of four members marked as FB204-037 and also marked individually as FB204A-X205E. This QA inspector observed numerous areas of undercut, overlap, abrupt transition of weld to base metal, and base metal gouges by both grinding and torch.

Caltrans OSM Quality Assurance Inspector Larry Viars observed the same or similar conditions on members marked as FB204-038, FB204-039, FB204-040, FB205-037, FB205-038, FB205-039, FB205-040. This QA inspector generated an incident report concerning the above noted issues. MT was not performed by either of the above noted Caltrans representatives.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

This QA inspector called QC1 by phone. QC1 told this QA inspector that another ZPMC QC inspector would arrive at Bay 8 in ten minutes. After a short time, ZPMC Quality Control CWI Guo Yan Fei (QC2) arrived at Bay 8 and observed the many markings made by this QA inspector on member FB204-037 and also marked individually as FB204A-X205E. QC2 informed this QA inspector that QC1 was withdrawing ZPMC notification of witness inspection #4288. This QA inspector told QC2 to inform QC1 that this QA inspector would generate an incident report for the above noted issues.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer